



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C250-100
Job Sheet 174914



Part No: C250-100

Job Qty: 3 ea

Part Name: Side Plate Cover



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C250-100 REV:4 IPP REV A 18.02.27 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		3/29/18	0.00	0.00	Start Up Maching		<i>OK 18/04/20</i>
110	Mori Seiki	3 pcs		3/29/18	0.00	3.00	MORI NV5000-1		<i>OK 18/04/20</i>
120	QC	3 pcs		3/29/18	0.00	0.00	QC2		<i>SC 18-04-21</i>
130	QC	3 pcs		3/29/18	0.00	0.00	QC8		<i>A.A 18-04-24</i>
150	Outsource	3 pcs		3/29/18	0.00	0.00	Outsource4		<i>CT 18-4-24</i>
160	Packaging	3 pcs		3/29/18	0.00	0.00	Packaging2		<i>AT 18/04/27</i>
170	QC	3 pcs		3/29/18	0.00	0.00	QC6		<i>D 18-04-25</i>
175	Small Fab	3 pcs		3/30/18	0.00	0.75	Small Fab-1		<i>MCL</i>
180	QC	3 pcs		3/30/18	0.00	0.00	QC5		<i>SB</i>
185	Packaging	3 pcs		3/30/18	0.00	0.00	Packaging3		<i>APR 2 8 2018</i>
190	QC21-SA	3 Ea		3/30/18	0.00	0.00	QC21		<i>GA - Alain</i>

AT 18/04/27

SB

APR 2 7 2018

21

Part Op 110 - 1-Machine as per folio FB

FOLIO REV:

DWG REV:

2-Deburr

Descriptions: 150 - Issue P/O to ATG. *120 - Engrave S/N using Marktronic engraver. See note 1 for location.*

sealant - Certificate of Conformity is required

175 - Laser Etch, white as per dwg.

P0039685

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S2.250X13.500	6061-T6 Sheet 2.250" Thick x 13.500" Wide	4.1400 ft (1.38 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S2.250X13.500	4	6	0



Container No: S063670



Part: C250-100

Job No: 174914

Serial No/Batch: S063670

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Part Specifications

Specifications could not be found.

Plex 3/23/18 9:16 AM Dart.lajeunesse.marie

Date: 04/21/18

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due		FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
OTHER :									

DART AEROSPACE LTD		Work Order: 174914
Description: SIDE PLATE COVER		Part Number: C250-100
Inspection Dwg: C250-100 Rev: 4		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.717	±.005	9.717	—		Probe	
2.207	±.005	2.207	—		Probe	
Ø.689	±.002	Ø.6888	—		Micr	
.03 X .45	±.010	.032	—		Vern M/L-08	
.915	±.005	.914	—		"	
.915	±.005	0.915	✓			
1.055	±.003	1.156	—		"	
.085	±.005	0.085	✓			
Ø.750	±.003	±.756	—		"	
Ø.156	±.005	0.157	✓			
Ø.323	±.006	Ø.323	—		"	
1.125	±.005	1.130	—		"	
6.763	±.005	6.763	—		Probe	
4.721	±.005	4.721	—		Probe	
Ø.9358	±.0005	Ø.9353	—		Micr	
1.290	±.005	1.289	—		Vern M/L-08	
1.145	±.003	1.146	—		"	
Ø.201	±.005	.2016	—		"	
.625	±.005	.630	—		"	
1.111	±.005	1.111	—		Probe	
7.831	±.005	7.831	—		"	
Ø.1001	±.005	1.0005	—		Micr	
1.165	±.005	1.164	—		Vern M/L-08	
Ø.1.501	±.005	1.505	—		Micr	
.081	±.005	.081	—		Vern Probe	
5.980	±.005	5.980	—		"	
Ø.6244	±.0005	.6248	—		Micr	
2.020	±.005	2.021	✓		Caliper	JCL-08
1.060	±.005	1.061	—		Vern M/L-08	
1.188	±.005	1.189	—		"	
.04 X .45	±.010	0.043	✓			

Measured by: Mx / J.C.L.	Checked by: A.F.	QC Inspector:
Date: 18/04/2018-21	Date: 18-04-24	Date:

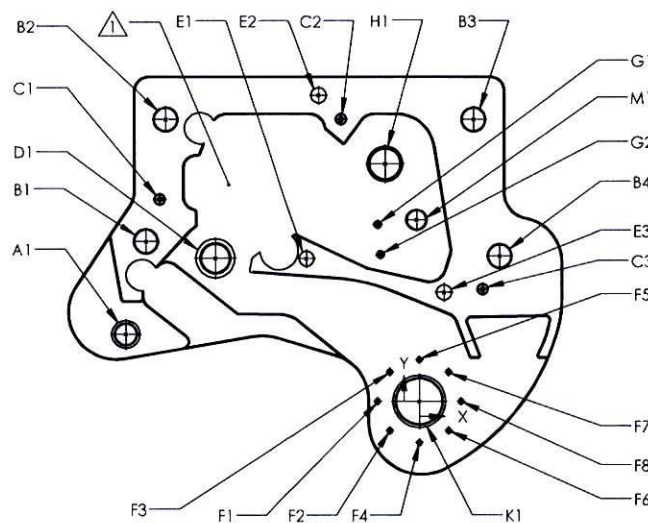
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Engine, LLC.

TAG	X LOC	Y LOC	SIZE
A1	-9.717	2.207	$\varnothing .689^{+.000}_{-.002}$ THRU ALL 2X .03 X 45° $\varnothing .915 \nabla 1.155^{+.003}_{-.000}$ $\varnothing .915 \nabla .085$ FAR SIDE
B1	-9.055	5.274	$\varnothing .750$ THRU ALL 2X .03 X 45°
B2	-8.407	9.299	
B3	1.793	9.299	
B4	2.659	4.796	
C1	-8.600	6.656	$\varnothing .156$ THRU $\varnothing .323 \nabla 1.125$.02 X 45° NEARSIDE
C2	-2.560	9.310	
C3	2.088	3.700	
D1	-6.763	4.721	$\varnothing .9363^{+.000}_{-.001}$ THRU ALL $\varnothing .9358$.04 X 45° NEARSIDE $\varnothing 1.290 \nabla 1.145^{+.003}_{-.000}$
E1	-3.712	4.709	$\varnothing .500$ THRU ALL
E2	-3.307	10.093	
E3	.817	3.592	10-32 UNF THRU ALL
F1	-1.368	.000	
F2	-.967	-.967	
F3	-.967	.967	
F4	.000	-1.368	
F5	.000	1.368	
F6	.967	-.967	
F7	.967	.967	
F8	1.368	-.000	$\varnothing .201 \nabla .625$.02 X 45°
G1	-1.356	5.828	
G2	-1.269	4.843	$\varnothing 1.001^{+.000}_{-.001}$ THRU ALL .03 X 45° NEARSIDE .04 X 45° FAR SIDE $\varnothing 1.165 \nabla 1.145^{+.003}_{-.000}$
H1	-1.111	7.831	
K1	.000	.000	$\varnothing 1.501^{+.000}_{-.001}$ THRU ALL .03 X 45° NEARSIDE $\varnothing 1.728 \nabla 1.145^{+.003}_{-.000}$
M1	-.081	5.980	$\varnothing .6248$ THRU ALL $\varnothing .6244$.03 X 45° NEARSIDE

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		AS DRAWN BY APICAL	6/12/2013	CFB	JAG
2		CHD M1 HOLE TOLERANCE WAS $\varnothing .627^{+.000}_{-.001}$ IS $\varnothing .6248^{+.000}_{-.001}$	6/28/2013	CFB	JAG
3	14-0128	CHD M1 HOLE CHAMFER WAS .03 X 15° E .03 X 45°	8/20/2013	CFB	JAG
4	15-0309	CHD TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CHD DIMS WAS (16.367) E 16.36, WAS (113.151) E 13.15. ADDED DMF NOTE. ADDED HOLE ∇ NOTE. DELETED CAUTION NOTE ENGRAVING. DELETED DIMS 7.27, $\varnothing 1.03$, 4.64, $\varnothing 1.28$, 9.19, $\varnothing 1.03$, 4.17, 4.98, 9.01. CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/14/2014	DPD	RW
			9/18/2015	DPD	JAG



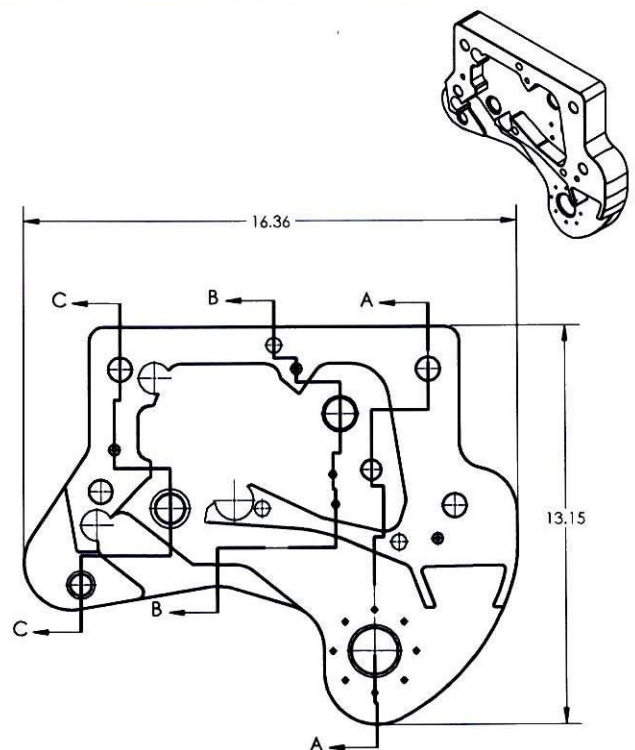
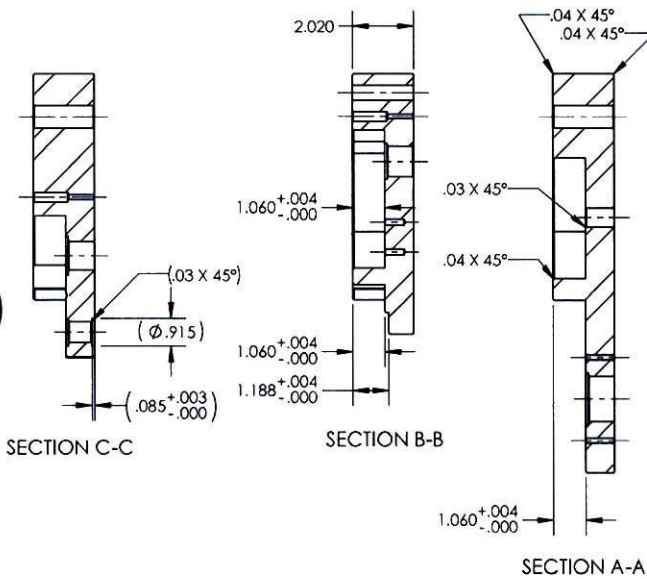
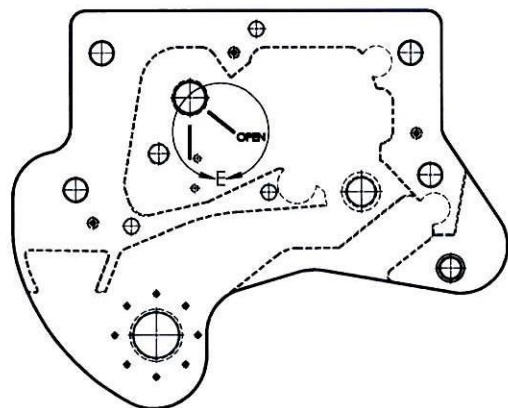
NOTE:

- 1 MACHINE ENGRAVE BATCH NUMBER.
2 HOLE ∇ CALLED FROM THIS SURFACE.

DART AEROSPACE	
TITLE SIDE PLATE COVER	
DWG NO. C250-100	REV 4
MAT'L 0001	DRAWN BY: APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED REXT TREAT FINISH BLACK ANODIZE SPEC MIL-A-8625 TYPE II, CLASS II USED ON MODEL
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 6/13/2011 SHEET 1 OF 2

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C250-100	1	SIDE PLATE COVER	6061	

REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
1		CHD M1 HOLE TOLERANCE WAS Ø.627 +.000-.001 IS Ø.6248-.6244.	6/28/2013	CF5	JAG	
2		CHD M1 HOLE CHAMFER WAS .03 X 15° IS .03 X 45°.	6/22/2013	CF5	JAG	
3	14-0128	CHD DIMS WAS (16.360) IS 16.36, WAS (13.115) IS 13.15. ADDED DXF NOTE.	8/14/2014	DFD	RW	
4	15-0309	DELETED CAUTION NOTE ENGRAVING DELETED DIMS 7.27, Ø1.03, 4.64, Ø1.28, 9.19, Ø1.03, 4.17, 4.98, 9.01.	9/18/2015	DFD	JAG	



NOTE:
USE DXF PROFILE FOR POCKET DETAILS.

USE DAT FROM FRONT OF LOCKER DETAILS			
			
TITLE SIDE PLATE COVER			
DWG NO. C250-100			REV 4
MATERIAL: 6061		DRAWN BY: APICAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XX.X .001 FRACTIONS & 1/8 XX .1 ANGLES 2.5°		APPROVED <i>D. Weir</i> REVISION PART BLACK ANODIZE	
SPEC MIL-A-8625, TYPE II, CLASS II		USED ON MODEL	
1. BREAK ALL SHARP EDGES .015 ± .45 OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE 1:4	DATE 6/13/2011	SHEET 2 OF 2	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039685**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039685
PO Date: 4/24/18
Due Date: 4/27/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174914	C250-100	Side Plate Cover -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	4/27/18	3 pcs	0 pcs	3 pcs	\$58.50/pcs	\$175.50
2	174913	C250-200	Side Plate Housing -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	4/27/18	4 pcs	0 pcs	4 pcs	\$58.50/pcs	\$234.00
Grand Total:										\$409.50

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/25/18 8:45 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(008715-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

008715- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET.
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
27-Apr-2018		Aman		039685				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C250-100 Rev.	C250-100 01-ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	3	3	0	0	0
2	C250-200 Rev.	C250-200 01-ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	4	4	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.